

Date: Thursday, 3/22/2007 2:41:46 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	ANGLE
Job Number	31441			
Estimate Number	10198			
P.O. Number	N/A		Part Number	D21752
This Issue	3/22/2007	S.O. No.	Drawing Number	D2175 REV E
Prsht Rev.	NC		Project Number	N/A
First Issue	N/A	Type	Drawing Revision	E
Previous Run	26496		Material	N/A
Written By			Due Date	3/30/2007
Checked & Approved By	M/07.03.22		Qty:	39
Comment	Um: Each			
Est E 04.06.09 Reformat KJ/RF Est Rev:F 06-04-28 Manufactured on Water Jet JLM Est Rev:G As per Rev E 06-11-22 JLM				

Additional Product

Job Number:		
Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S063	2024-T3 .063 sheet 
Comment: Qty.: 0.4958 sf(s)/Unit Total : 19.8324 sf(s) Material: 2024-T3 (QQ-A-250/4) 0.063" thick (M2024T3S.063) Batch: M/03/21 M/07/03/26 (39)		
2.0	WATER JET	FLOW WATER JET 
Comment: FLOW WATER JET 1-Cut as per Dwg D2175 Dwg Rev: E M/07/03/26 (39) Prog Rev: E		
2-Deburr if necessary		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 
Comment: INSPECT PARTS AS THEY COME OFF MACHINE M/07/03/26 (39)		
4.0	QC8	SECOND CHECK 
Comment: SECOND CHECK M/07/03/28 (39)		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr Stack M/07/03/28 (39)		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/03/00
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/22/2007 2:41:46 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ANGLE

Job Number: 31441

Part Number: D21752

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Form as per Dwg D2175

SB 07/03/29

(39)

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

J 0703-29

8.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

07-03-29 (39)

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

SB

07/03/29 (38)

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 07/03/29 (38)

11.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

ED 07/03/30

Job Completion:



U 0703-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31441
Description: Angle	Part Number:	D2175-11-2
Inspection Dwg: D2175	Rev: D E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

6
07.03.22

Measured by:	<i>MJ</i>	Audited by:	<i>J</i>	Prototype Approval:	N/A
Date:	<i>07 03 26</i>	Date:	<i>07 03 26</i>	Date:	N/A

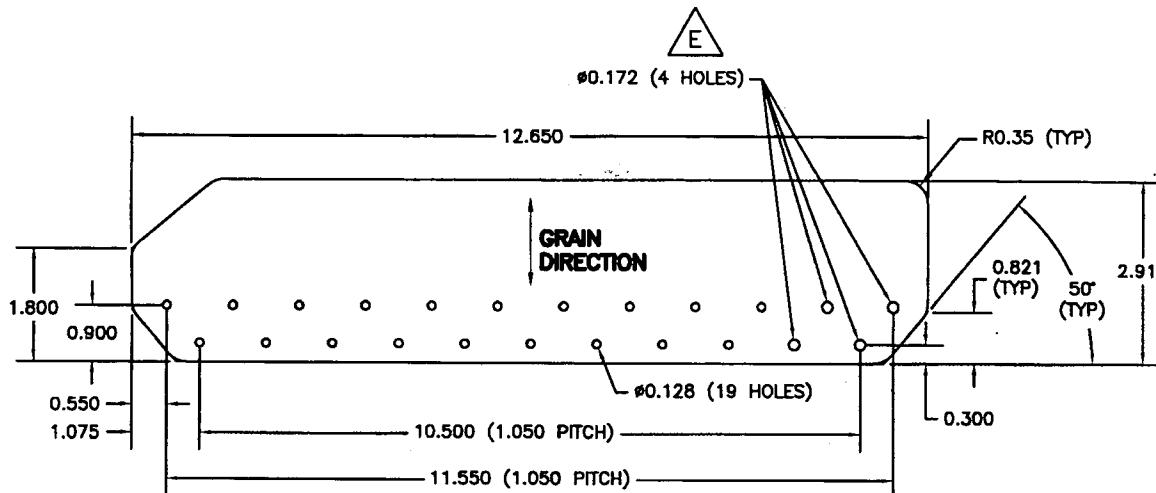
Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	JLH

10

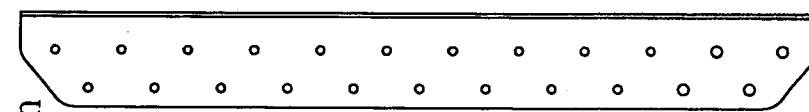
DART

RELEASED
06.10.13

DESIGN RF	DRAWN BY CE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED JH	APPROVED M	DRAWING NO. D2175
DATE 06.09.25	TITLE ANGLE	SHEET 1 OF 1
		SCALE 1:3



**D2175-1 BEND DETAIL SHOWN
(D2175-2 BENT OPPOSITE)**



SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 2144

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) ALL DIMENSIONS ARE IN INCHES

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